

State of Vermont
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November 13, 2014

Schultz Construction, Inc.
PO Box 2620
Ballston Spa, NY 12020

Project Name: Rochester ER BRF 0162(18)

Structure Identification: VT 73 Bridge #19 over the White River

The proposed welding procedure submitted on Monday, November 10, 2014 for the above project (General Contractor – Schultz Construction) have been reviewed and are being returned herewith.

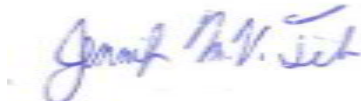
The welding procedures must be revised and resubmitted.

Please address the following comments:

- 1) I see the material specification calls for grade 50 but I don't see that its weathering steel, which I think it should be. Is this going to be painted or galvanized after welding? The WPS doesn't call out what electrode will be used but I see there is an attached spec sheet on the 7018 rods. These rods do not have weathering characteristics and therefore can only be used where the finished weldment is painted (or has some sort of protective coating).
- 2) The welding position should be horizontal (assuming the sole plate will be flat with the girder sitting on the plate in its upright position). In order for this weld to be done in the flat position, the girder would have to be rotated at 45 degree angle +/-.
- 3) The drawing shows a 1.5" sole plate and by scaling, the bottom flange appears to be thicker. If this is correct, and the bottom flange is thicker than 1.5" then the pre heat temperature should be 150 deg. F. (instead of 70 deg. As listed on the WPS).

Please feel free to contact Chris D. Williams, Resident Engineer, at (802) 498-4170 with any questions.

Sincerely,



Jennifer M. V. Fitch, P.E.
Project Manager

Attachments

cc: [x] Resident Engineer – Chris D. Williams
[x] File